

Split

DART AEROSPACE LTD	Work Order: 22709 <i>A</i>
Description: Dual Disabling Kit (Medium Bell)	Part Number: D412-738-011 <i>D3393-041</i>
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1	Keyed: <input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike Qty: <i>8</i> 50
	Page 1 of 3

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	U	05/03/14	88																				
2	DC	Photocopy bluefile and create labels per PPP D412-738-011 CHG001	N/A	N/A	N/A																				
3	GA	Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2728-7</td><td>Decal</td><td>M15464</td></tr><tr><td>1</td><td>D3373-1</td><td>Cam Lock B 22575</td><td></td></tr><tr><td>1</td><td>D3393-1</td><td>Battery Lock Casing</td><td>B 22479C</td></tr><tr><td>1</td><td>D3393-3</td><td>Cam Lock Shaft</td><td>B 22556B</td></tr></table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal	M15464	1	D3373-1	Cam Lock B 22575		1	D3393-1	Battery Lock Casing	B 22479C	1	D3393-3	Cam Lock Shaft	B 22556B	SA	05/03/14	8
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal	M15464																						
1	D3373-1	Cam Lock B 22575																							
1	D3393-1	Battery Lock Casing	B 22479C																						
1	D3393-3	Cam Lock Shaft	B 22556B																						
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	SB	05/03/14	8																				
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5	SA	05/03/14	8																				
6	GA	Assemble D3393-041 as per Dwg D3393. Insert lock body and fasten with lock body nut, apply locktite, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3393-3 shaft into lock, then install decal. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3369-5</td><td>Washer</td><td>B 22709</td></tr><tr><td>2</td><td>5/16WC</td><td>SS Flat Washer</td><td>M15715</td></tr><tr><td>A/R</td><td>N/A</td><td>262 Locktite</td><td>M16517</td></tr></table> Identify as D3393-041 and attach keys. Ensure that assembly locks and unlocks smoothly. Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer	B 22709	2	5/16WC	SS Flat Washer	M15715	A/R	N/A	262 Locktite	M16517	SB	05/03/14	8				
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer	B 22709																						
2	5/16WC	SS Flat Washer	M15715																						
A/R	N/A	262 Locktite	M16517																						
7	WS	Tack Weld lock shaft to flat cam Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>A/R</td><td>N/A</td><td>SS Rod</td><td>N/A</td></tr></table>	Qty	Part Number	Description	Batch	A/R	N/A	SS Rod	N/A	PD	05-03-14	8												
Qty	Part Number	Description	Batch																						
A/R	N/A	SS Rod	N/A																						
8	GA	Apply krazy glue to caps then press caps into body. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>9567K21</td><td>Polyethelene Cap</td><td>M16964</td></tr><tr><td>A/R</td><td>N/A</td><td>Krazy Glue</td><td></td></tr></table>	Qty	Part Number	Description	Batch	2	9567K21	Polyethelene Cap	M16964	A/R	N/A	Krazy Glue		SA	05/23/14	8								
Qty	Part Number	Description	Batch																						
2	9567K21	Polyethelene Cap	M16964																						
A/R	N/A	Krazy Glue																							
9	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick:<table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3368-1</td><td>Pedal Lock Base</td><td></td></tr><tr><td>1</td><td>D3368-3</td><td>Pedal Lock Cover</td><td></td></tr><tr><td>1</td><td>D3385-1</td><td>Hinge</td><td></td></tr></table>Identify as D3368-051	Qty	Part Number	Description	Batch	1	D3368-1	Pedal Lock Base		1	D3368-3	Pedal Lock Cover		1	D3385-1	Hinge		N/A	N/A	N/A				
Qty	Part Number	Description	Batch																						
1	D3368-1	Pedal Lock Base																							
1	D3368-3	Pedal Lock Cover																							
1	D3385-1	Hinge																							
10	QC3	Inspect Powder Coat																							

DART AEROSPACE LTD		Work Order:	22709
Description: Dual Disabling Kit (Medium Bell)		Part Number:	D412-738-011 D3393-041
		Keyed:	<input checked="" type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3368 Rev. A; D3369 Rev. A1 page 4; D3371 Rev. A page 4; D3393 Rev. A page 1		Qty:	80
		Page 2 of 3	

Step	Location	Procedure	By	Date	Qty																				
11	GA	Press dowel pins into D3368-3 pedal lock cover, then assemble hinge as per Dwg D3368 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-7</td> <td>Cam Lock</td> <td></td> </tr> <tr> <td>3</td> <td>238-028</td> <td>Ø3/16" Dowel Pin ½" long</td> <td></td> </tr> <tr> <td>4</td> <td>385-039</td> <td>Flat Head Screw</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-7	Cam Lock		3	238-028	Ø3/16" Dowel Pin ½" long		4	385-039	Flat Head Screw				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-7	Cam Lock																							
3	238-028	Ø3/16" Dowel Pin ½" long																							
4	385-039	Flat Head Screw																							
12	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.																							
13	GA	Fabricate D3371-5 Cam Lock as per Dwg D3371 Identify as D3371-5																							
14	GA	Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>262 Locktite</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	262 Locktite																
Qty	Part Number	Description	Batch																						
A/R	N/A	262 Locktite																							
15	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td></td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td></td> </tr> <tr> <td>28"</td> <td>CBL-1240</td> <td>Cable</td> <td></td> </tr> </tbody> </table> Identify as D3384-047	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock		2	CBL-460	Loop Sleeve		28"	CBL-1240	Cable								
Qty	Part Number	Description	Batch																						
1	D3384-1	Cyclic Sock																							
2	CBL-460	Loop Sleeve																							
28"	CBL-1240	Cable																							
16	GA	Assemble D3384-047 to D3368-051 using ¼"-20 socket head cap screw and washer as per Dwg D3368. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td></td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>¼"-20 SHCS 3/8" long</td> <td></td> </tr> </tbody> </table> Identify as D3368-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer		1	HX-81	¼"-20 SHCS 3/8" long												
Qty	Part Number	Description	Batch																						
2	AN960-416	Washer																							
1	HX-81	¼"-20 SHCS 3/8" long																							
17	QC5	Inspect work to Step 16																							
18	PK	Ensure that keys are attached to D3368-041 and D3393-041 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3368-041</td> <td>Pedal Lock Assembly</td> <td></td> </tr> <tr> <td>1</td> <td>D3393-041</td> <td>Battery Lock Assembly</td> <td>B22709</td> </tr> </tbody> </table> Ensure that keys can be locked and unlocked for each D3368-041 and D3393-041 assembly.	Qty	Part Number	Description	Batch	1	D3368-041	Pedal Lock Assembly		1	D3393-041	Battery Lock Assembly	B22709											
Qty	Part Number	Description	Batch																						
1	D3368-041	Pedal Lock Assembly																							
1	D3393-041	Battery Lock Assembly	B22709																						
19	QC4	Inspect Kit 100% for Completeness on the W/O																							
20	PK	Identify and pack for shipping as per PPP D412-738-011																							
21	AC	Cost / part: 7.73																							
22	DC	Close W/O 11.91 Inspect Level 21																							

